

Date: Friday, 5/25/2007 8:26:09 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE, OUTBOARD, RH, 206
Job Number : 32623
Estimate Number : 10523
P.O. Number : N/A Part Number : D26652
This Issue : 5/25/2007 S.O. No. : N/A Drawing Number : D2665 REV. D
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : MACHINED PARTS Drawing Revision : D
Previous Run : 29389 Material : N/A
Due Date : 6/30/2007 Qty: 12 Um: Each
Written By :
Checked & Approved By : *Jim. 05.28*
Comment : Est: C 00.11.01 Removed P/O for Powder Coat - in
house process EC
Est Rev:D As per Rev D 07-03-19 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101003 7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
7075-T7351 2X6.25X7.875
Cut Size 2.0" x 6.25" x 7.88" Grain Along Long 7.88 Length *325349* *EC 07-04-26* *(12)*

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
1- Program batch number
2- Machine Step # 1 of Folio and visually inspect as per attached Dimension Sheet
3- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet
4- Machine Step # 3 of Folio and visually inspect as per attached Dimension Sheet
5- Deburr *J.F. 1/5.1*

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet *J.F. 1/5.1* *07/10/03*

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE *J.F. 1/5.1* *07/10/03*

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK *J.F. 07/10/03*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 21/10/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:26:09 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, RH, 206

Job Number: 32623

Part Number: D26652

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



12x

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-1

07/10/09

7.0

POWDER COATING

POWDER COATING



M105068

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MS 07-10-09 (12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/10/09 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/10/09 (12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

07/10/11

Job Completion



u 07-10-10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32623
Description: 206 Saddle, Outboard, Right side	Part Number:	D2665-2
Inspection Dwg: D2665 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.120"	.114	0.122	0.121		
B	0.100	0.140		.121"	.119	0.116	0.114		
C	1.125	1.145		1.139"	1.138	1.136	1.137		
D	0.615	0.685		.677"	.675	.675	.675		
E	0.240	0.260		.255"	.252	0.246	0.246		
F	1.313	1.343		1.313"	1.327	1.326	1.328		
G	0.210	0.230		.226"	.219	0.219	0.217		
H	0.100	0.180		.132"	.135	.135	.135		
I	2.470	2.510		2.496"	2.495	2.495	2.495		
J	1.565	1.585		1.570"	1.567	1.576	1.575		
K	0.235	0.240		.239	.238	0.237	0.237		
L	0.100	0.120		.110"	.111	0.110	0.112		
M	0.990	1.010		.997"	.997	0.995	0.998		
N	0.510	0.515		.513	.513	.513	.513		
O	5.990	6.010		6.008"	6.001	6.001	6.001		
P	1.245	1.255		1.250"	1.250	1.250	1.250		
Q	2.495	2.505		2.501"	2.500	2.500	2.500		
R	0.313	0.318		.313"	.314	.314	.314		
S	0.315	0.322		.319"	.319	.319	.319		
T	2.495	2.505		2.499"	2.500	2.499	2.499		
U	1.357	1.367		1.364"	1.362	1.361	1.362		
V	0.787	0.807		.801"	.798	0.793	0.795		
W	0.540	0.560		.556"	.551	0.551	0.550		
X	1.674	1.684		1.680"	1.679	1.678	1.678		
Y	0.257	0.262		.258"	.258	.258	.258		
* Z	0.912	0.932		.932"	.923	0.926	0.924		
AA	0.490	0.510		.505"	.501	0.506	0.506		
AB	0.178	0.198		.188"	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: J.F.	Audited by: J.F.
Date: 07/10/09	Date: 07/10/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order:	32623
Description: 206 Saddle, Outboard, Right side	Part Number:	D2665-2
Inspection Dwg: D2665 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.122	0.124	0.128	0.128		
B	0.100	0.140		0.116	0.116	0.123	0.123		
C	1.125	1.145		1.140	1.140	1.145	1.135		
D	0.615	0.685		0.675	0.675	0.675	0.680		
E	0.240	0.260		0.247	0.251	0.253	0.253		
F	1.313	1.343		1.327	1.328	1.328	1.328		
G	0.210	0.230		0.226	0.223	0.225	0.225		
H	0.100	0.180		0.138	0.140	0.140	0.140		
I	2.470	2.510		2.494	2.492	2.491	2.494		
J	1.565	1.585		1.574	1.577	1.585	1.573		
K	0.235	0.240		0.237	0.237	.238	.238		
L	0.100	0.120		0.109	0.111	0.109	0.108		
M	0.990	1.010		0.998	0.999	1.000	0.998		
N	0.510	0.515		0.510	0.510	.513	.513		
O	5.990	6.010		6.001	6.000	6.000	6.001		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.499	2.500	2.506		
R	0.313	0.318		0.314	0.314	0.314	0.314		
S	0.315	0.322		0.320	0.326	0.326	0.320		
T	2.495	2.505		2.499	2.499	2.499	2.499		
U	1.357	1.367		1.362	1.360	1.360	1.360		
V	0.787	0.807		0.794	0.795	0.795	0.795		
W	0.540	0.560		0.548	0.542	0.550	0.550		
X	1.674	1.684		1.677	1.678	1.678	1.678		
Y	0.257	0.262		0.258	0.258	0.258	0.258		
Z	0.912	0.932		0.924	0.925	0.922	0.923		
AA	0.490	0.510		0.500	0.501	0.500	0.500		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>ML</i> / <i>J.L</i>
Date:	07/09/30

Audited by:	<i>J.F</i>
Date:	07/00/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order:	32623
Description: 206 Saddle, Outboard, Right side	Part Number:	D2665-2
Inspection Dwg: D2665 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.127	0.127	0.126	0.127		
B	0.100	0.140		0.121	0.123	0.122	0.123		
C	1.125	1.145		1.137	1.137	1.136	1.137		
D	0.615	0.685		0.680	0.678	0.677	0.680		
E	0.240	0.260		0.253	0.253	0.253	0.252		
F	1.313	1.343		1.330	1.331	1.330	1.330		
G	0.210	0.230		0.224	0.225	0.224	0.225		
H	0.100	0.180		0.141	0.140	0.137	0.140		
I	2.470	2.510		2.493	2.493	2.493	2.493		
J	1.565	1.585		1.574	1.573	1.574	1.575		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		0.110	0.110	0.110	0.110		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.513	.513	.513	.513		
O	5.990	6.010		6.001	6.001	6.001	6.001		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.499	2.499	2.500		
R	0.313	0.318		0.314	0.314	0.314	0.314		
S	0.315	0.322		0.320	0.320	0.320	0.320		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		0.795	0.795	0.795	0.795		
W	0.540	0.560		0.550	0.550	0.550	0.549		
X	1.674	1.684		1.678	1.678	1.628	1.628		
Y	0.257	0.262		0.258	0.258	0.258	0.258		
Z	0.912	0.932		0.923	0.923	0.923	0.923		
AA	0.490	0.510		0.500	0.501	0.500	0.500		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

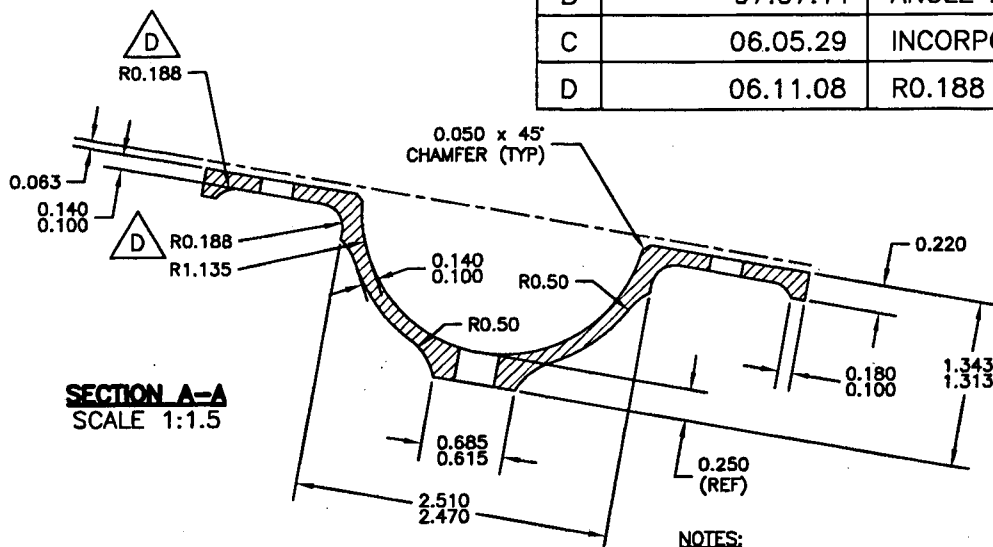
Measured by: *SmL*
Date: *07/10/01*

Audited by: *J.B*
Date: *07/10/03*

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2665	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE FWD OUTSIDE HIGH	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$	

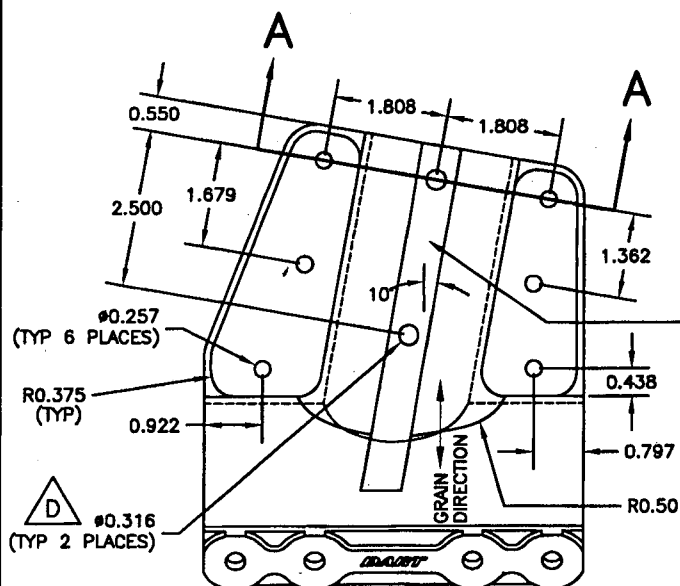


RELEASED

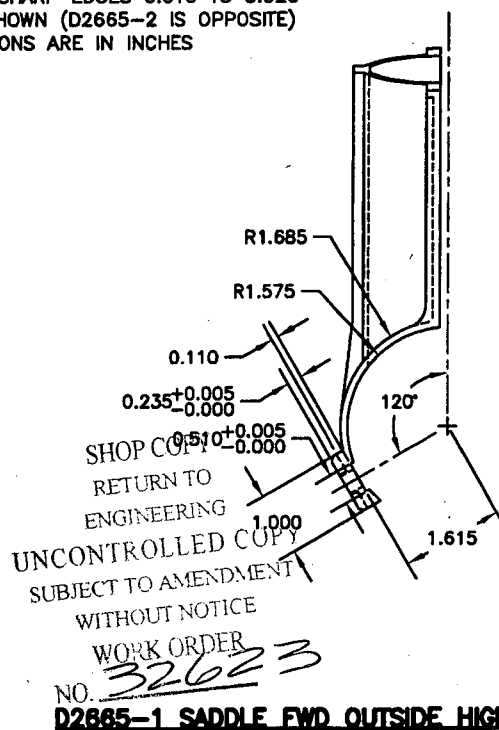
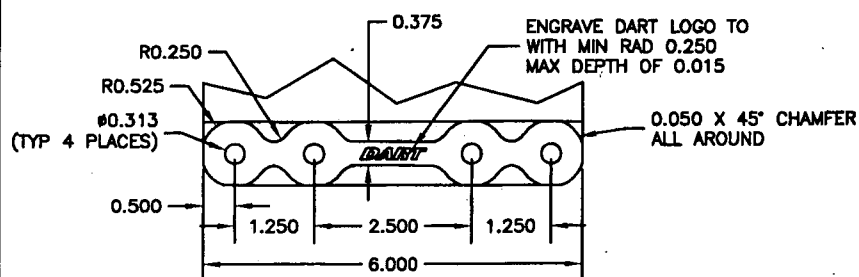
07.02.12

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010



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